



TECHNICAL DATA SHEET

6INH34XXX HYDRO OVEN

Waterbased oven finishing
(CONVERTER)

DESCRIPTION

Waterborne thermosetting melamine-polyester finishing with good general performances as toughness, elasticity, chemical resistances. It can be applied directly on steel surfaces, in order to protect electrical switchboards, little tanks, cylinders and in all those cases when it's needed to assure the artefacts particular toughness, glossy effect or high resistance, with optimized costs, when an oven drying system is available.

TINTOMETRIC SYSTEM

CONVERTERS	PASTES
feasible	NO

PERFORMANCE DATA

DESCRIPTION	METHOD	VALUE
Viscosity	Seconds Ford Cup 4/8	100-120 (f/4)
Specific weight	gr/lt	1150-1250
Solid by weight	%	55-60
Theoretical coverage	m ² /lt	5-6
Theoretical consumption	gr/m ²	150-170
Thickness of moist film	Micron	60-70
Thickness of dried film	Micron	40-45
Colour	Visual	All shades
Gloss	Gloss (60°)	60-70
Temperature resistance	°C	150 in continuous 230 at intermittence

SHELF LIFE

8 months stored in its unopened original can (temperature from +5 to 40°C).



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APPLY

PRODUCT CODE	Component A	6INH34XXX
	Component B	
	Thinner	Water
MIXING RATIO	In weight	100:30
	In volume	
POT-LIFE (at 20°C)		
APPLY CONDITIONS	Temperature	0-45 °C
	Relative humidity	0-80 %
SPRAY TOOLS	Apply	conventional
	Nozzle (mm)	1.4-1.7
	Air pressure kg/cm ²	3.5-4
	Thinning (%)	0-10
	Apply	Airless
	Nozzle (mm)	0.018-0.021
	Air pressure kg/cm ²	Compression ratio 30:1 (pressure 150-180 kg/cm ²)
	Thinning (%)	0-10

TOOLS

Conventional spray, immersion.

DRYING TIME

AIR DRYING (20°C)	Overcoatable	
	Fully	
	In depth	
OVEN DRYING	Overcoatability	
	Temperature	120°C
	Time	20 minutes

CHEMICAL- PHYSICAL



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MECHANICAL RESISTANCE	Sea-fog test	DIN EN ISO 4628-3:1982,ASTM B117	Corrosion propagation (after 200h) on lower 2 mm cut
	Humid cabin test	300 h, temperature 70°C, UR 95%	No blistering
	Superficial toughness	Method : DUR-O-METER	4 H

THE ABOVE REPORTED DATA ARE THE RESULT OF LABORATORY TESTS, THEREFORE THEY ARE APPROXIMATE AND DO NOT REPRESENT A WARRANTY FOR THE PERFORMED WORK.

SURFACE PREPARATION

Black plate: phosphating, phospho-degreasing or chemical pickling. Aluminum or galvanized steel: apply as anchor an epoxy or polyvinyl butyral undercoat, waterborne or solventborne. The enamel can be applied after 20-30 minutes drying.

RECOMMENDED UNDERCOATS / FINISHINGS

Directly on the surface or on artifacts pretreated with epoxy undercoats or primers, with polyvinyl butyral resins water-based or solvent-based.

RECOMMENDED

Industrial atmosphere.

UNRECOMMENDED

Immersion in both fresh and salt water.

INSTRUCTIONS

TDS 006